

Date: Friday, 10/12/2007 1:11:52 PM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: DOUBLER	
Job Number	: 35155		Part Number	: D314087	
Estimate Number	: 11461		Drawing Number	: D3140 REV F	
P.O. Number	:		Project Number	: N/A	
This Issue	: 10/12/2007	S.O. No. :	Drawing Revision	: F	
Prsht Rev.	: NC		Material	:	
First Issue	: / /	Type : SMALL /MED FAB	Due Date	: 10/19/2007	
Previous Run	: 27345		Qty:	8	
Written By	:		Um:	Each	
Checked & Approved By	:				
Comment	: Est. A02.04.30 New Issue NG Est. Rev B New dwg rev. ecn781 06.04.18 EC Est. rev.C added scuffing NCR 061 EC Est Rev:B As per ECN #829 06-11-20 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M2024T3S032	2024-T3 .032 sheet	
		Comment: Qty.: 2.1966 sf(s)/Unit Total : 4.3932 sf(s) 2024-T3 .032 sheet Matl: 2024-T3 (QQ-A-250/4) .032" thick (M2024T3S.032) (43" x 7" ref) Batch M10555 HB 07-10-15	
2.0	SHEAR	SHEAR	
		Comment: SHEAR Cut as per dwg D3140	
		water set. HB 07-10-15	
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Scuff surfaces with 80grit sandpaper per QSI 006	
		2-Deburr. HB 07-10-15 No sharp edges	
		SAN 07-10-15	8
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	 5 07/10/15 X8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:	Machine Or Operation:	Description :
5.0	HAND FINISHING	HAND FINISHING RESOURCE #1
		Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <i>FZ 07/10/16 (8)</i>
6.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
		Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION <i>FB 07/10/16 (8)</i>
7.0	PACKAGING 1	PACKAGING RESOURCE #1
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: _____ <i>FB 07/10/16 (8)</i>
8.0	QC21	FINAL INSPECTION/W/O RELEASE
		Comment: FINAL INSPECTION/W/O RELEASE <i>07.10.16 HJ</i>

Job Completion



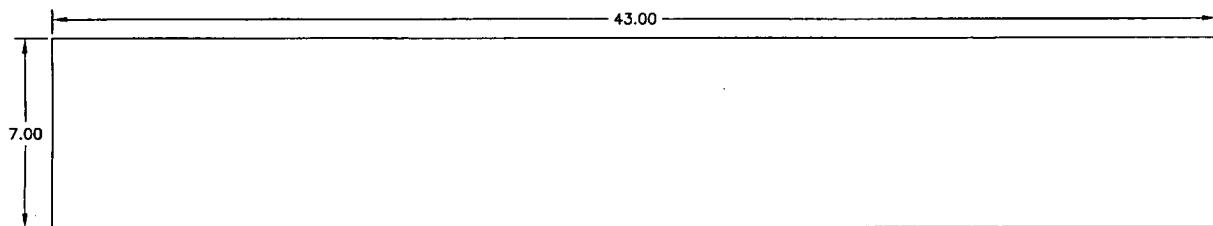
in std. b

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

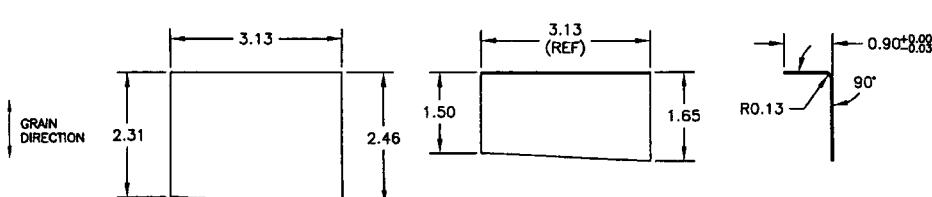
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



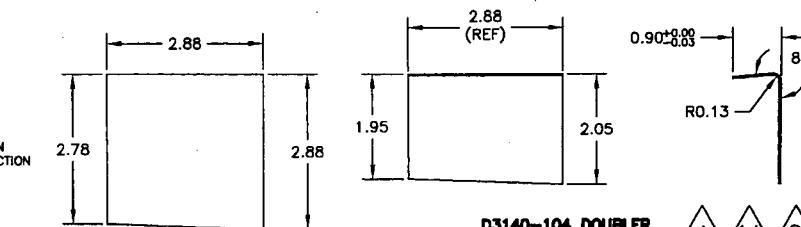
D3140-87 DOUBLER 4 14
(REPLACES PREMIER P/N B30-23000-87)



D3140-105F FLAT PATTERN
(USED TO MAKE D3140-105/-106 BRACKETS)

D3140-105 DOUBLER
D3140-106 OPPOSITE

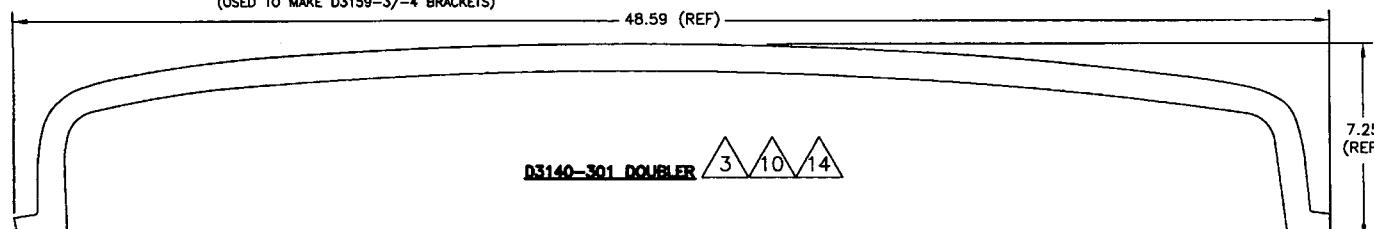
4 14 D



D3140-104 DOUBLER
D3140-103 OPPOSITE

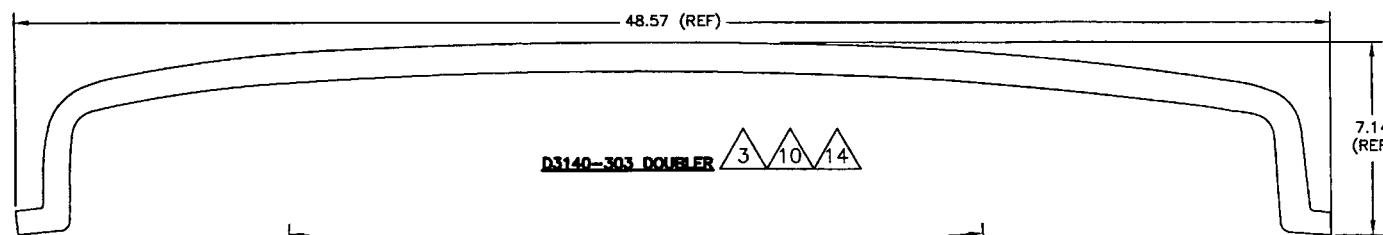
4 14 D F

D3140-103F FLAT PATTERN
(USED TO MAKE D3140-103/-104 BRACKETS)

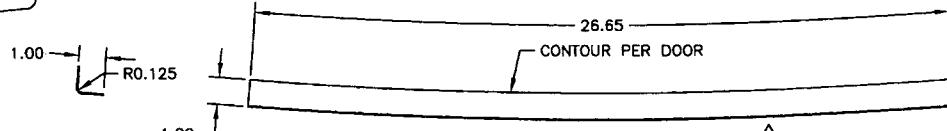


RELEASED
06/11/13

D3140-301 DOUBLER 3 10 14



D3140-303 DOUBLER 3 10 14



D3140-85 ANGLE 6
FLAT PATTERN: 26.65" x 1.90"
(REPLACES PREMIER P/N B30-23000-85)

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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAWKESBURY, ONTARIO, CANADA
4	CB		REV. F
CHECKED	APPROVED		DRAWING NO.
			D3140
DATE		TITLE	SCALE
06.10.06		DOOR	NTS

DART AEROSPACE LTD	Work Order:	
Description: Dow1RSEd	Part Number:	D 3140 -87
Inspection Dwg: 3140 Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	HB	Audited by:	E	Prototype Approval:	N/A
Date:	07-10-16	Date:	07/10/16	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	